

Work Order ID 82708

82708

Page 1

April-05-12 11:18:26 AM

Item ID: D3442-3

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Shim

Stop

NS2

Start Date: 05/04/2012 Start Qty: 12.00

12

Cust Item ID:

Required Date: 12/04/2012 Req'd Qty: 12.00

12

Customer:

Reference:

Approvals: Process Plan: MLJ

Date: 12/04/05

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D3442

B

100

0.00

100

FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3442

Dwg Rev: B

B12-4-8

Prog Rev: B 2-

Deburr if necessary

304.035

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.00

Quality Control

120

QC8- Inspect parts - second check

0.00

120

QC

Memo

0.00

Quality Control

5.2/04/09

(14)

(14)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Shim

Start Date: 05/04/2012 Start Qty: 12.00

12

Cust Item ID:

Required Date: 12/04/2012 Req'd Qty: 12.00

12

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

Identify as per dwg & Stock Location: _____

0.00

130

Packaging

Memo

0.00

Packaging

*****STOCK IN BASKET CELL*****

12.04.11 (14x)

140

QC21- Final Inspection - Work Order Release

0.00

140

QC

Memo

0.00

Quality Control

12/4/12

MF 12-04-11

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Picklist Print

April-05-12 11:18:30 AM

Page 1

Work Order ID: 82708

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Parent Item: D3442-3

D3442-3

Parent Item Name: Shim

Start Date: 05/04/2012

Required Date: 12/04/2012

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP A05.09.02New issueKJ/JLM
IPP B 07.07.23 waterjet EC verified by:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M304S22GA

Purchased

No

100

sf

141.9000

0.025

0.315789

5

M304S22GA

**

B12-4-8

304/316 .032 Sheet

Location

Loc Qty

Loc Code

MAT020

141.9

118271

12.9

120866

129

120866

(14)

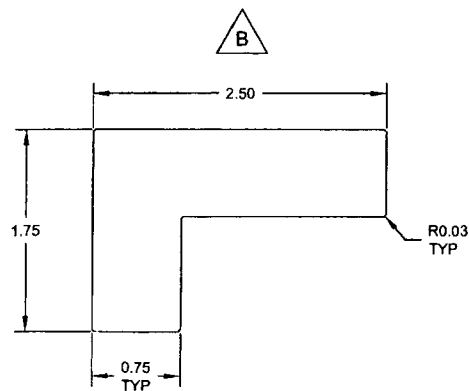
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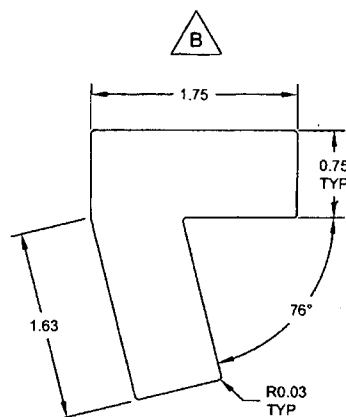
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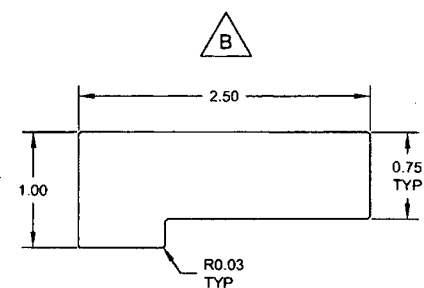
NOTE: Date & initial all entries



D3442-1 SHIM



D3442-3 SHIM



D3442-5 SHIM

STOP COPY
RETURN TO
ENGINEERING
CONTROLLED COPY
DIRECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

82708 MJS

12/04/05

RELEASED
2011-05-30

NOTES:

1) MATERIAL D3442-1/-3: AISI 304/316 STAINLESS STEEL SHEET PER AMS 5513 OR 5524
OR ASTM A240 OR ASME SA240
22 GAUGE (0.031 THICK)
REF. DART SPEC. M304S22GA

D3442-5: AISI 304/316 STAINLESS STEEL SHEET PER AMS 5513 OR 5524
OR ASTM A240 OR ASME SA240
16 GAUGE (0.063 THICK)
REF. DART SPEC. M304S16GA

- 2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: 0.03 lbs APPROX

B	REFORMAT. MATERIAL FOR -1 & -3 WAS 21 GAUGE. TOLERANCE UPDATED FOR ALL PARTS (SEE PAR 10-005)		AJS	11.05.26
A	NEW ISSUE		PH	05.06.03
REV.	DESCRIPTION		BY	DATE
DESIGN	PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
DRAWN	AJS			
CHECKED	A	DRAWING NO.	REV. B	
MFG. APPR.	E	D3442	SHEET 1 OF 1	
APPROVED	W	TITLE	SCALE	
DE APPR.	W	SHIM	NTS	
DATE	11.05.26		COPYRIGHT © 2005 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

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